

Date: Monday, 12/01/2009 9:12:12 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CONNECTOR PLATE
 Job Number : 44594
 Estimate Number : 13709
 P.O. Number :
 This Issue : 12/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D38671
 Drawing Number : D3867 PRELIM
 Project Number : N/A
 First Issue : / / Type : SMALL / MED FAB Drawing Revision : PRELIM
 Material :
 Due Date : 15/01/2009 Qty: 5 Um: Each
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 09-01-09 new issue DD verified by:EC

Additional Product

Job Number:



PRELIMINARY ISSUE
 09.01.12 POL EON 44594



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S040 6061-T6 .040 Sheet



Comment: Qty.: 0.1202 sf(s)/Unit Total : 0.6011 sf(s)
 6061-T6 .040 Sheet
 batch: 105842 1B 9-1-B

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3867
 Dwg Rev: PRE
 Prog Rev: Lim

1B 9-1-B

6

2- Deburr if necessary 1B 9-1-B

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1B 9-1-B

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ENGINEERING
 APPROVAL

09.01.15

09.01.14

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

09.01.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 9:12:12 AM
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Drawing Name: CONNECTOR PLATE

Job Number: 44594

Part Number: D38671

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(6)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 09/01/14

7.0

PACKAGING 1

PACKAGING RESOURCE #1



DM S-

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-15

POSITIVE RECALL
EFFECTIVE 09-01-12 AUTH 4
RELEASED DATE 09.02.12

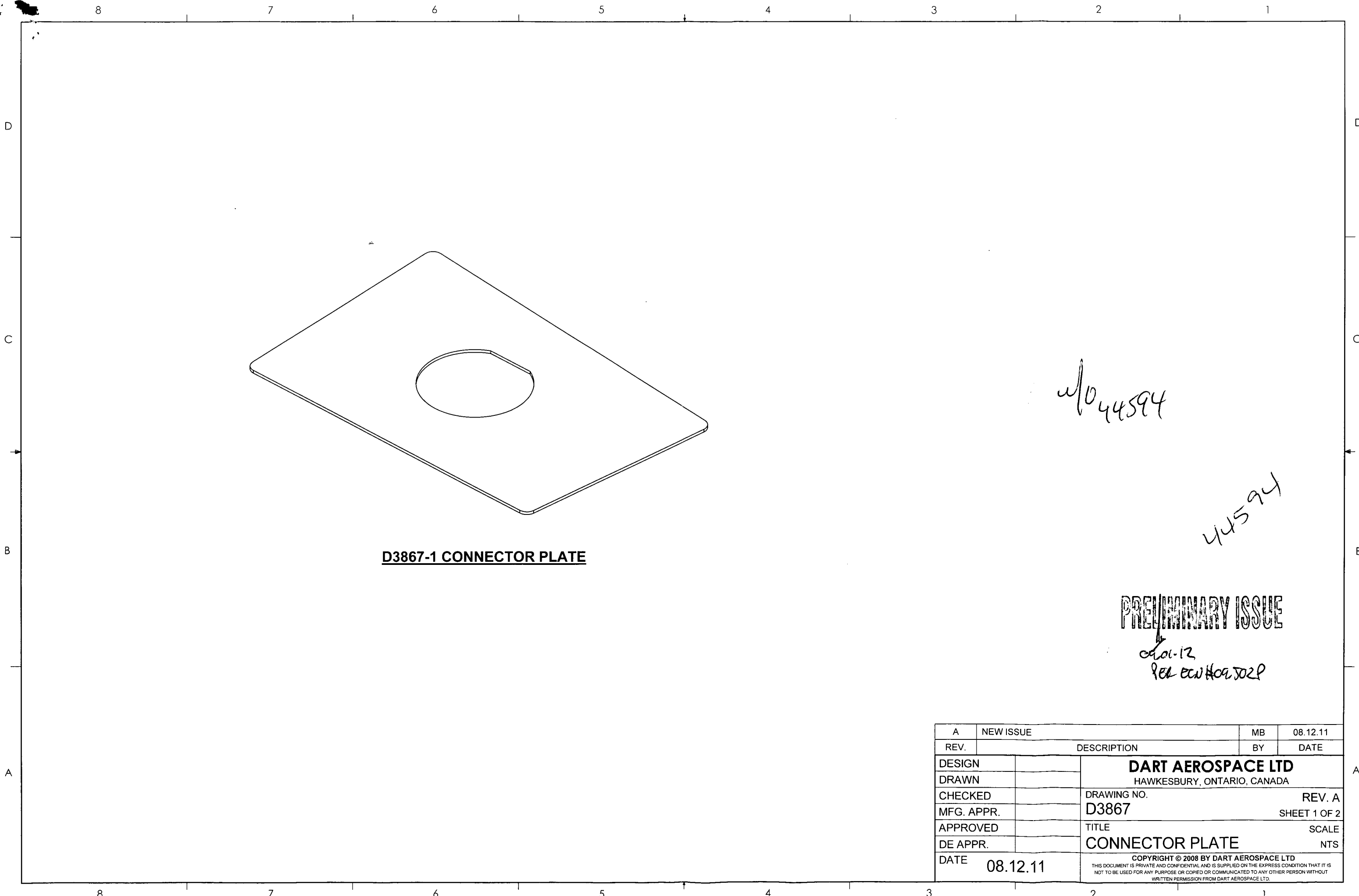
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



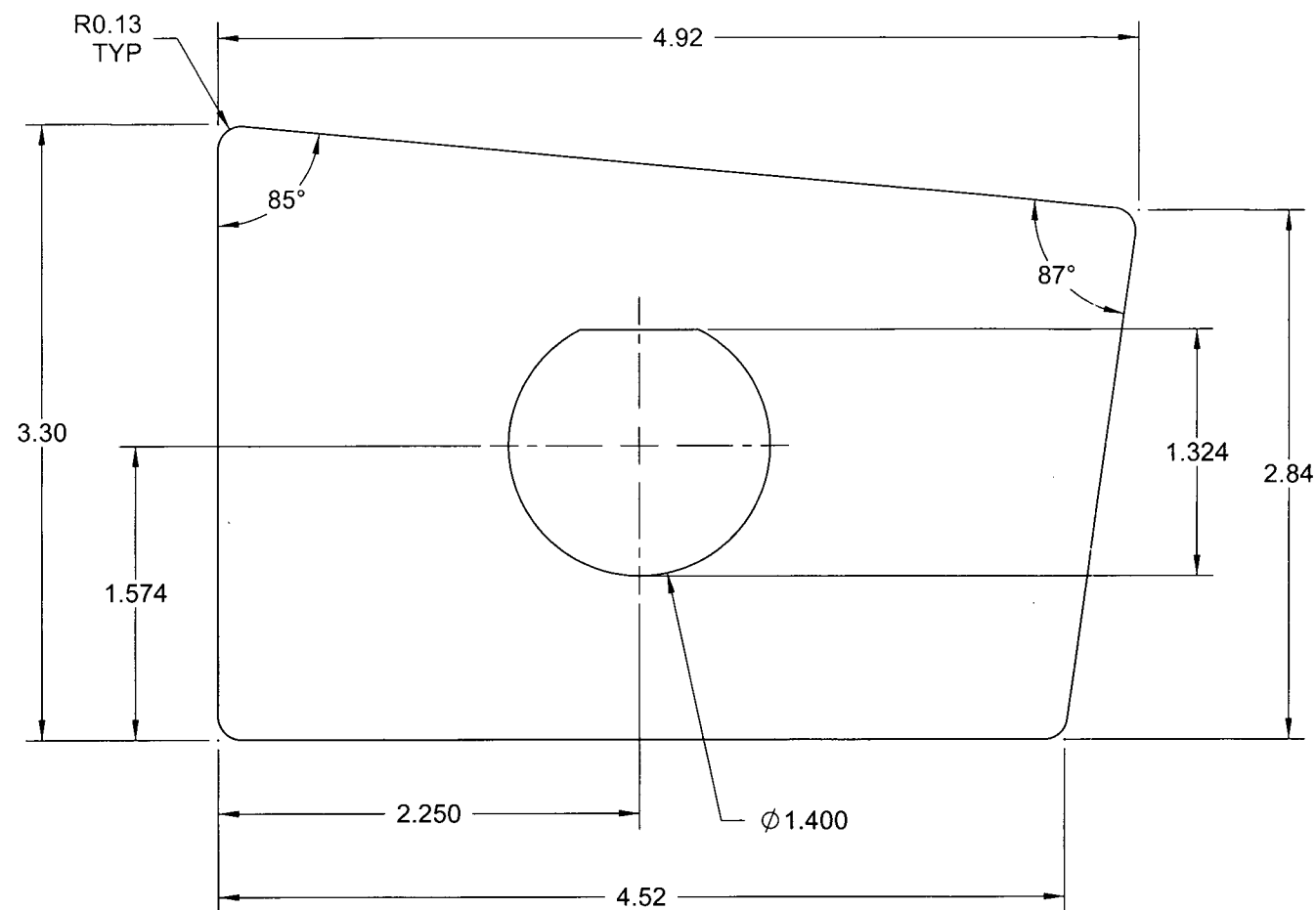
D3867-1 CONNECTOR PLATE

44594

44594

PRELIMINARY ISSUE
08.12.11
REV. ECN 44594

A	NEW ISSUE		MB	08.12.11
REV.	DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3867	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		CONNECTOR PLATE	NTS	
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D3867-1 CONNECTOR PLATE

44574
 PRELIMINARY ISSUE
 09.01.12
 Rev E00#09.02.12

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
 (REF. DART SPEC. M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3867-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3867	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CONNECTOR PLATE	NTS
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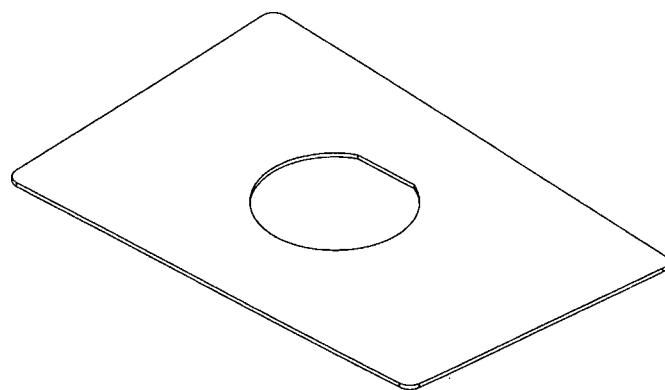
8 7 6 5 4 3 2 1

D

C

B

A



D3867-1 CONNECTOR PLATE

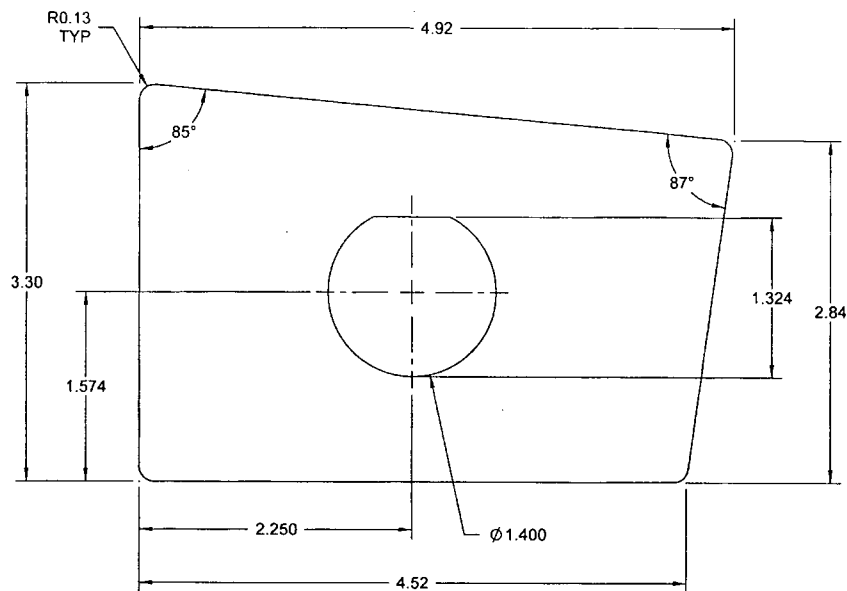
44594

RELEASED
07/02/05 JLB

A	NEW ISSUE	MB	08.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.12.11		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3867	REV. A SHEET 1 OF 2
TITLE CONNECTOR PLATE	SCALE NTS
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8 7 6 5 4 3 2 1



D3867-1 CONNECTOR PLATE

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RELEASED
07/12/05 JWP

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3867	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CONNECTOR PLATE	NTS
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